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D4038-1

Job Sheet 187148



Part No: D4038-1

Job Qty: 2 ea

Part Name: Angle, Fwd, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4038 REV.F SHEET 3 lpp Rev:A New Issue 09-12-15 JLM Verified By:EC IPP REV:B 18.02.08 DWG
REV.F VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-2		19/01/13
100	Bandsaw	2 pcs	12/14/18	12/14/18	0.00	0.14	Bandsaw1		11
110	CNC Vertical Machining	2 pcs	12/14/18	12/14/18	0.57	1.55	HAAS1-4		11
120	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC2 Machining-2		11
130	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-2		19/01/14
140	HandFinish	2 pcs	12/14/18	12/14/18	0.00	0.21	HandFinish1		D.R. 19/01/14
150	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC3		38
160	Packaging	2 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-2	506999	JAN 15 2019
170	QC21-SA	2 Ea	12/14/18	12/14/18	0.00	0.00	QC21		JAN 15 2019

Part Op 100 - Cut Blank 7.125" long

Descriptions: 110 - Mill as per Dwg & Folio FA880 Dwg Rev: _____ Folio Rev: _____ Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6A4.000W.250	6061T6 Angle 4.00 X 4.00 X .250	1.2000 ft (.6 ea)	90-Start up Operation	2.91 5068499-3

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6A4.000W.250	1	20	0



Container No: S144399



Part: D4038-1

Job No: 187148

Serial No/Batch: S144399

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/13/19

tions

ot be found.

Plex 11/28/18 9:57 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
FAULT CATEGORY					
ssure/Forced ding shing ks p/Kink/Ripple/Wave/Twist ks/Chatter labeled etails:		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	

DART AEROSPACE LTD		Work Order: 187148
Description: Angle, Fwd, LH		Part Number: D4038-1
Inspection Dwg: D4038	Rev: F	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	+/-0.030	3.440	/		vern	mml-05
1.25	+/-0.030	1.249	/			
4.00	+/-0.030	3.999	/			
1.25	+/-0.030	1.244	/			
R0.25	+/-0.030	0.25	/		Rad G	
0.250	+/-0.010	0.251	/		vern	mml-05
2.877	+/-0.010	2.877	/			
0.581	+/-0.010	0.580	/			
0.669	+/-0.010	0.669	/			
0.708	+/-0.010	0.708	/			
0.500	+/-0.010	0.500	/			
2.00	+/-0.030	2.00	/			
0.563	+/-0.010	0.563	/			
Ø0.316	+0.006/-0.001	0.319	/			
Ø0.189	+0.005/-0.001	0.191	/			
R0.13	+/-0.010	0.130	/		RG	
1.00	+/-0.010	1.00	/		vern	mml-05
1.063	+/-0.010	1.063	/			
1.563	+/-0.010	1.560	/			
0.50	+/-0.030	0.500	/			
7.00	+/-0.030	7.003	/			
1.750	+/-0.010	1.750	/			
0.882	+/-0.010	0.880	/			
R0.13	+/-0.030	0.130	/		RG	
0.911	+/-0.010	0.910	/		vern	mml-05
2.125	+/-0.010	2.125	/			
1.00	+/-0.030	1.00	/			
1.19	+/-0.030	1.190	/			

Measured by: mml	Checked by:	QC Inspector:
Date: 19/01/13	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.04.05	Dwg Rev updated	KJ	
C	11.06.21	Dimensions updated per Dwg Rev E	KJ	
D	16.05.30	Dwg Rev updated	KJ	
E	18.07.31	Dwg Rev updated	KJ	